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8. TEST PROCEDURE SHEET

	Accumulator incoming & outgoing inspection con		company: 🔏	LDC	date: 12/30/2008	7
	Fill in by hand.		engineer: Ra	ki Huang		-
Step	Action	Monitoring	Value	Result	Comment	√
1.	Record test equipment in appendix 1					
2.	Record inspection type (is it incoming or outgoing?)		Incoming /outgoing	Incoming		─ ✓
3.	Component comes from	origin		SYSU		/
4.	Component goes to	destination		AIDC		V
5.	Part number					

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	Accumulator incoming & outgoing inspection		company:		date:	
	Fill in by hand.		engineer:		location:	
Step	Action	Monitoring	Value	Result	Comment	
6.	Serial number	<u>, 1977 (</u>				
7.	Record model type		QM /FM	FMI	Used for TTCB-QM	
		,		P/ [box afterworks	
8.	Visual inspection, unaided eye, look at outer surface for	scratches			107 01 (01 001)01	
	- scratches	dents				
	- dents	fitting				
9.						
	Take pictures of the accumulator from all sides					
10.	Accumulator dimension check		TTCB0100_2;			
	(Write the measured values in the Appendix drawings)	·	ET5998-07;			
`			TTCB0100_3			
11.	Clamp dimension check		TTCB010201			
	(Write the measured values in the Appendix drawings)					
12.	Slide dimension check		TTCB010501			
	(Write the measured values in the Appendix drawings)					

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	Accumulator incoming & outgoing inspection		company:		date:	
	Fill in by hand.		engineer:		location:	
Step	Action	Monitoring	Value	Result	Comment	14
13.	Check the bolt types					
14.	Check the torque of Clamp Bracket-Collar bolts (NAS1351N08-14)		22.8 In*lbf -26.9			
15.	Check the torque of Pipe Fix-Clamp bolts (NAS1351N06-10)		13.3 ln*lbf -15.7	1		
16.	Check the torque of Press-Saddle bolts (NAS1351N08-12)	· .	22.8 In*lbf -26.9			
17.	Check the heater resistance					
	Resistance of FAC_a	Resistance	20. 9±1 Ω	21.90		
	2. Resistance of FAC_b	Resistance	20. 9±2 Ω	21.6.0		
18.	Check the electric insulation of heater					
	Electric insulation of FAC_a	Resistance	>20Mohm	OPEN		\

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	Accumulator incoming & outgoing inspection		company:		date:	
	Fill in by hand.		engineer:		location;	
Step	Action	Monitoring	Value	Result	Comment	[√
	Electric insulation of FAC_b	Resistance	>20Mohm	OPEN		
19.	Check the Peltier element resistance					
	Resistance of Peltier element 1	Resistance	3.4±1Ohm@25℃	4652		\
	2. Resistance of Peltier element 2	Resistance	3.4±1Ohm@25℃	4752		
	3. Resistance of Peltier element 3	Resistance	3.4±1Ohm@25℃	46.0		. 🗸
	4. Resistance of Peltier element 4	Resistance	3.4±1Ohm@25℃	450		
20.	Check the electric insulation of Peltier element					
	Electric insulation of Peltier element 1	Resistance	>20Mohm	OPEN		
	2. Electric insulation of Peltier element 2	Resistance	>20Mohm	OPEN		

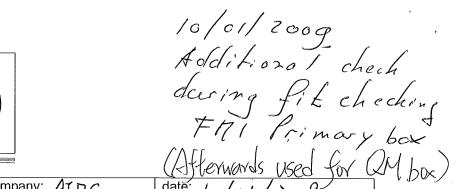
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	Accumulator incoming & outgoing inspection		company:		date:	
	Fill in by hand.		engineer:		location:	
Step	Action	Monitoring	Value	Result	Comment	- $ $
	3. Electric insulation of Peltier element 3	Resistance	>20Mohm	OPEN		
	4. Electric insulation of Peltier element 4	Resistance	>20Mohm	OPEN		1
21.	He leak test: Measure equipment background level (put cap on tester, without test item being connected)	Background Leak Rate	<2*10 ⁻¹⁰ mbar.l/s	CIXIÖO mbar.1/5		V
22.	He leak test: Connect test item and measure leak rate value without spraying helium	Leak Rate	<2*10 ⁻¹⁰ mbar.l/s	< 1×1000 mbar.1/s		~
23.	He leak test: Connect test item and cover it with a plastic bag and measure and record the leak rate value when the plastic bag is filled with helium	Leak Rate	<1*10 ⁻⁹ mbar.l/s	< 1×10 ¹⁰ mbax. 1/5		\ <u></u>
24.	Disconnect the accumulator liquid pipe from the leak tester					-
25.	He leak test: Measure equipment background level (put cap on tester, without test item being connected)	Background Leak Rate	<2*10 ⁻¹⁰ mbar.l/s	<1×10 ¹⁰ mbar.1/s		V
26.	He leak test: Connect test item and measure leak rate value without spraying helium	Leak Rate	mala m m 1/m	<1×10° mbar. 1/5		

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	Accumulator incoming & outgoing inspection		company:		date:		
	Fill in by hand.		engineer:		location:		
Step	Action	Monitoring	Value	Result	Comment	1	
27.	He leak test: Connect test item and cover it with a plastic bag and measure and record the leak rate value when the plastic bag is filled with helium	Leak Rate	<1*10 ⁻⁹ mbar.l/s	<1×10° mbar.1/s		/	
28.	Disconnect the Peltier pipe from the leak tester					~	
·	End of sheet						

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	Accumulator incoming & outgoing inspection		company: AID	C	date: 10/01/2009	
	Fill in by hand.		engineer: Raki	Huang	location: J2303	
Step	Action	Monitoring	Value	Result	Comment	1
13.	Check the bolt types					
14.	Check the torque of Clamp Bracket-Collar bolts		22.8 In*lbf -26.9			
	(NAS1351N08-14)		In*lbf			Ł.
15.	Check the torque of Pipe Fix-Clamp bolts (NAS1351N06-10)		13.3 ln*lbf -15.7			
			In*lbf			
16.	Check the torque of Press-Saddle bolts (NAS1351N08-12)		22.8 In*lbf -26.9			
		Victoria	In*lbf			
17.	Check the heater resistance					
	Resistance of FAC_a	Resistance	20. 9±1 Ω	22.4Ω		
	2. Resistance of FAC_b	Resistance	20.9±2Ω	22.10		
18.	Check the electric insulation of heater					
	Electric insulation of FAC_a	Resistance	>20Mohm	Over 25MD		

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	Accumulator incoming & outgoing inspection		company:	company: engineer:		
	Fill in by hand.	***************************************	engineer:			
Step	Action	Monitoring	Value	Result	Comment	1
	Electric insulation of FAC_b	Resistance	>20Mohm	Over 17 M.D.	, and the second	
19.	Check the Peltier element resistance			7 7 7 12.22		
	Resistance of Peltier element 1	Resistance	3.4±1Ohm@25℃	4.4Ω		,
	2. Resistance of Peltier element 2	Resistance	3.4±1Ohm@25℃	\$1202		
	3. Resistance of Peltier element 3	Resistance	3.4±1Ohm@25℃	£,3.Ω		
	4. Resistance of Peltier element 4	Resistance	3.4±1Ohm@25℃	4.3 Ω		
20.	Check the electric insulation of Peltier element					
	Electric insulation of Peltier element 1	Resistance	>20Mohm	OPEN		
	Electric insulation of Peltier element 2	Resistance	>20Mohm	OPEN		
	14.00			L		

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	Accumulator incoming & outgoing inspection		company:		date:	***************************************
	Fill in by hand.		engineer:		location:	
Step	Action	Monitoring	Value	Result	Comment	1
	3. Electric insulation of Peltier element 3	Resistance	>20Mohm	OPEN		
	4. Electric insulation of Peltier element 4	Resistance	>20Mohm	OPEN		
21.	He leak test: Measure equipment background level (put cap on	Background	<2*10 ⁻¹⁰ mbar.l/s			
	tester, without test item being connected)	Leak Rate				
22.	He leak test: Connect test item and measure leak rate value	Leak Rate	<2*10 ⁻¹⁰			
	without spraying helium		mbar.l/s			
23.	He leak test: Connect test item and cover it with a plastic bag	Leak Rate	<1*10 ⁻⁹ mbar.l/s			
	and measure and record the leak rate value when the plastic bag					
	is filled with helium					
24.	Disconnect the accumulator liquid pipe from the leak tester					
25.	He leak test: Measure equipment background level (put cap on	Background	<2*10 ⁻¹⁰ mbar.l/s			
	tester, without test item being connected)	Leak Rate				
26.	He leak test: Connect test item and measure leak rate value	Leak Rate	<2*10 ⁻¹⁰			
	without spraying helium		mbar.l/s			
				I		

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9. APPENDIX 1 TEST EQUIPMENT

Test equipment	Manufacturer and type	Calibration / functiona		
		check		
		Date	Next Date	
Multimeter	Agilent 34401A	07/24/2008	07/24/2009	
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·	- vid responses			
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10. APPENDIX 2 ACCUMULATOR DRAWINGS